

Date: Wednesday, 3/14/2007 3:27:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 204 STEP LUG	
Job Number	: 31209				
Estimate Number	: 11843				
P.O. Number	: N/A		Part Number	: D23381	
This Issue	: 3/14/2007	S.O. No.	: N/A	Drawing Number	: D2338 REV B U/R
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: 3/14/2007	Type	: MACHINED PARTS	Drawing Revision	: B
Previous Run	:		Material	: N/A	
Written By	:		Due Date	: 3/23/2007	
Checked & Approved By	:		Qty:	6	Um: Each
Comment	: Est. B00.03.24 Separated -1 from -2 EC		OK to Go 3/14/07.15		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"  
	Comment: Qty.: 0.3827 f(s)/Unit Total : 2.2964 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 0.5 x 6.0" Batch: <u>71103438</u>	<i>ML 07/03/19</i>
2.0	BAND SAW	BAND SAW  
	Comment: BAND SAW Cut Blanks 8.75" long	<i>ML 07/03/19</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2338 Tumble & Deburr	<i>SD/ML 07/03/19</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SD 07.03.20</i>
5.0	QC8	SECOND CHECK  
	Comment: SECOND CHECK	<i>J.F. 07/03/20 (6)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Wednesday, 3/14/2007 3:27:38 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 STEP LUG

Job Number: 31209

Part Number: D23381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 07/3/22

(6)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/3/23

Job Completion



07/3/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



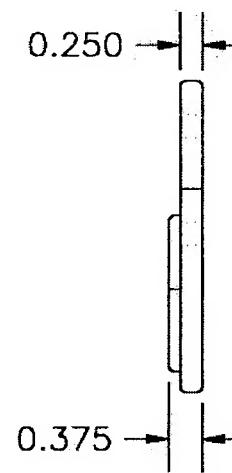
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	REV. B	
R3	R3	DRAWING NO.	SHEET 1 OF 1
DATE		D2338	SCALE
95:01:25		TITLE	1:2
B	96.03.29	ENDPLATE	
		RE-DESIGN AND ADD D2338-2	

RELEASED

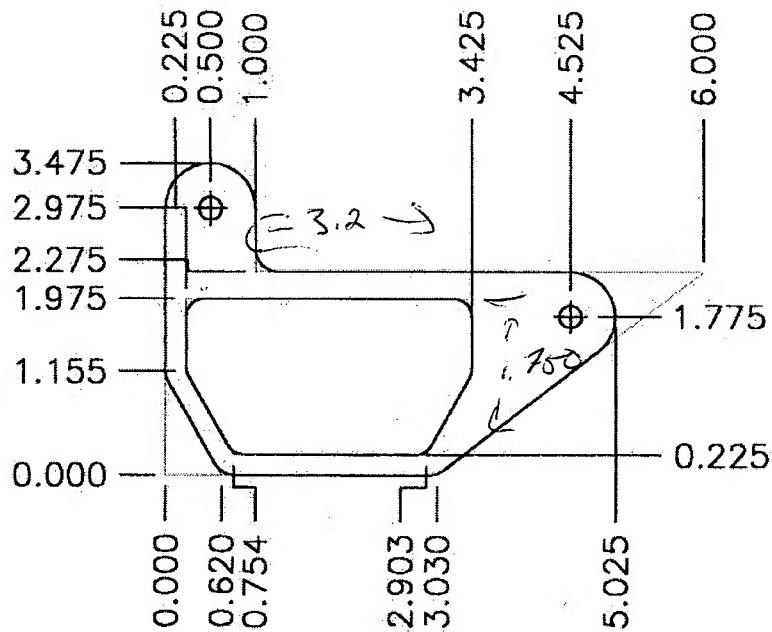
(97/04/22)

UNDER REVIEW

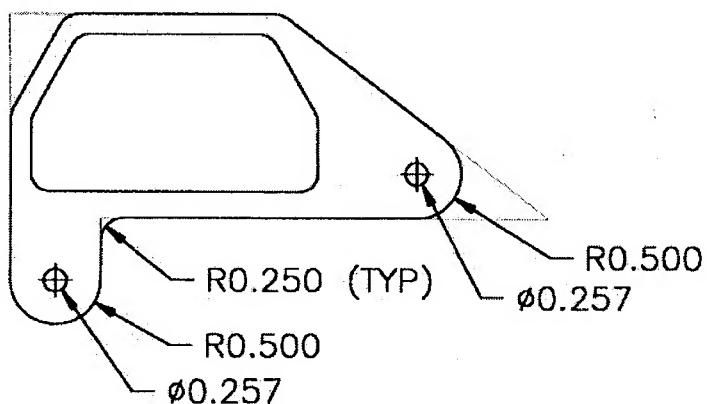
02. 0. 11



D2338-1



D2338-2



MATERIAL: 6061-T6, 0.25 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 312 09

DART AEROSPACE LTD	Work Order:	31209
Description: D2338 Endplate	Part Number:	D2338-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.975	± .010	1.980	/			
B .225	± .010	.225	/			
C 2.275	± .010	2.277	/			
D 3.475	± .010	3.478	/			
E .225	± .010	.226	/			
F .500	± .010	.500	/			
G 1.000	± .010	1.001	/			
H 3.425	± .010	3.421	/			
I 4.525	± .010	4.526	/			
J 5.025	± .010	5.029	/			
K						
L .250	± .010	.250	/			
M .375	± .010	.369	/			
N						
O Ø.257		Ø.257	/			
P R.500		R.508	/			
Q R.250		R.250	/			
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SA	Audited by:	J.F.	Prototype Approval:	N/A
Date:	07/03/20	Date:	07/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

